
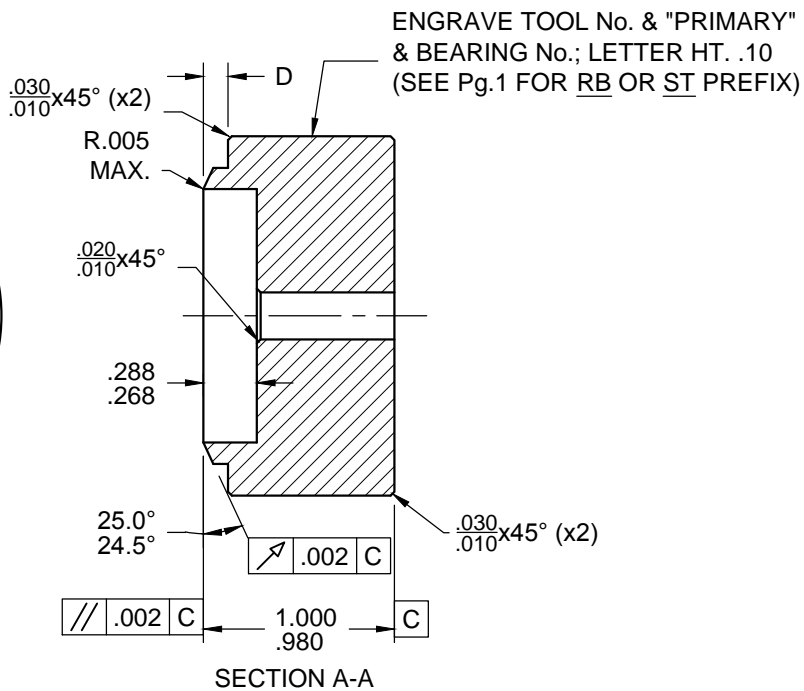
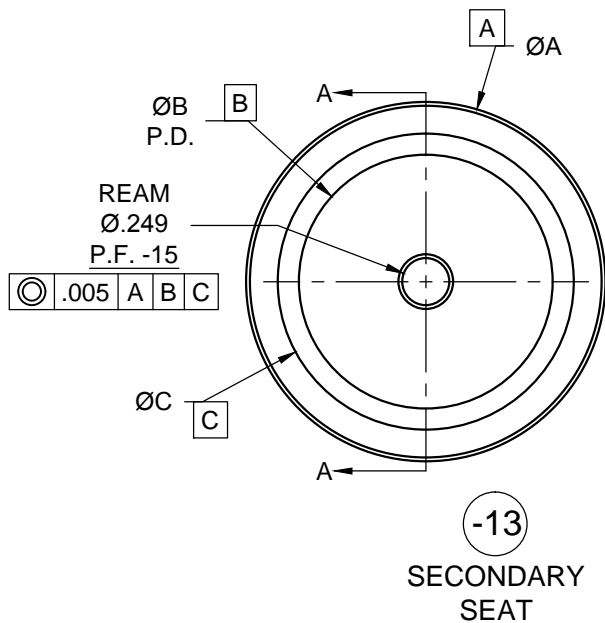
[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).

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| | | | |
|---|---------------------|--|-----------------|
|  RED BARN MACHINE | | | |
| TITLE RBST2300 SERIES SWAGING TOOL; LOCATING PIN | | | |
| DWG NO. TOOL# (see chart)-15 | | | REV 3 |
| UNLESS OTHERWISE SPECIFIED TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1 | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. TOLERANCE LIMITS APPLY AFTER PLATING | | | |
| SCALE NTS | DATE 6-27-08 | SHEET 9 | of 9 |

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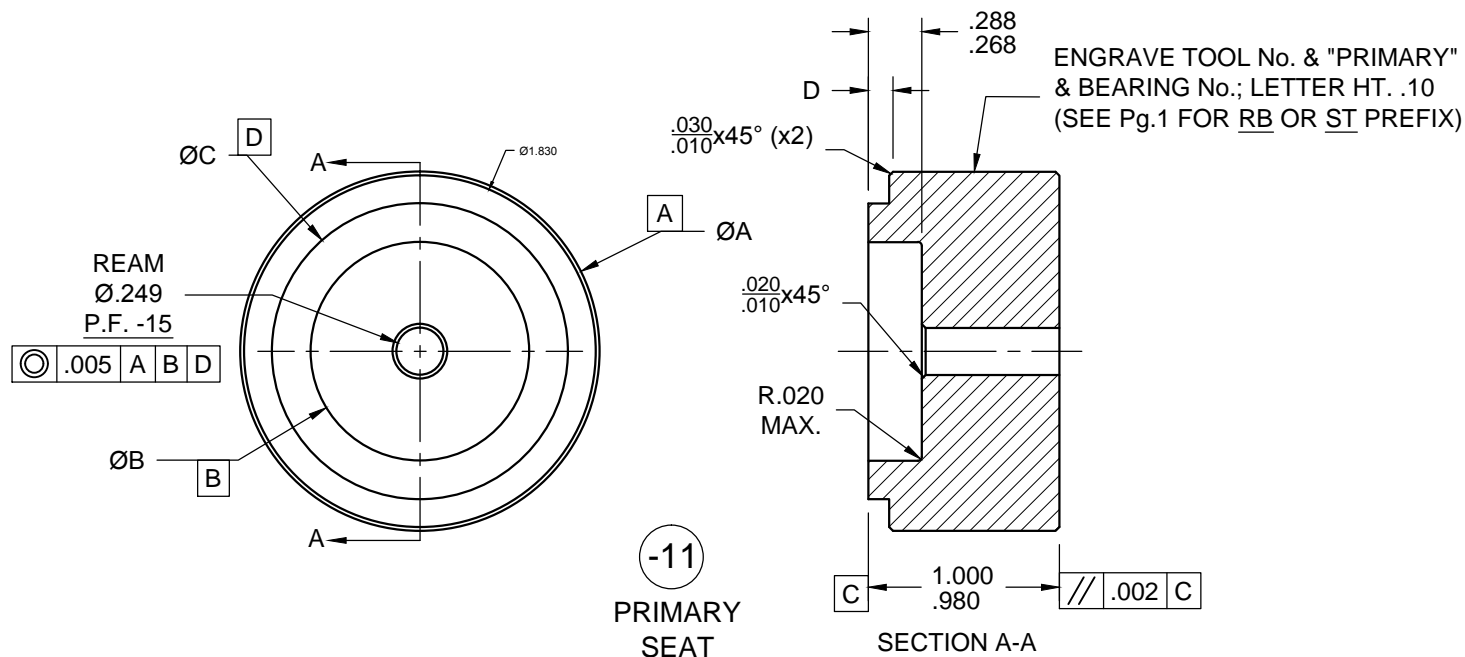
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NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


| | | | |
|--|------------|---|----------------|
|  RED BARN MACHINE | | | |
| TITLE | | RBST2300 SERIES | |
| | | SWAGING TOOL; SECONDARY SEAT | |
| DWG NO. | | TOOL# (see chart)-13 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1 | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | | |
| SCALE | NTS | DATE | 6-27-08 |
| | | SHEET | 8 of 9 |

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[illegible]

NOTES


1. BREAK ALL SHARP CORNERS (.015/.03).

| | |
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|  RED BARN MACHINE | |
| TITLE RBST2300 SERIES SWAGING TOOL; PRIMARY SEAT | |
| DWG NO. TOOL# (see chart)-11 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1 |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | |
| SCALE NTS | DATE 6-27-98 |
| SHEET 7 of 9 | |

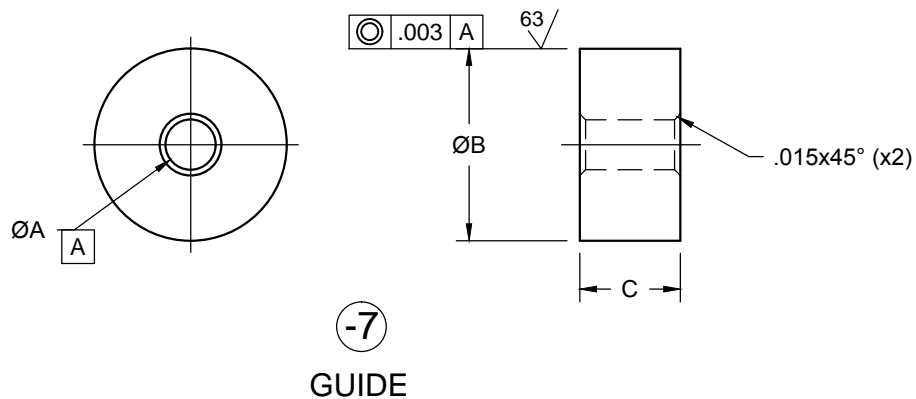
Technical drawing of a hole. It shows a circle with a smaller circle inside, representing a hole. A leader line points from the hole feature symbol (a rectangle with 'A' inside) to the hole. The symbol is labeled with the diameter symbol \varnothing and the letter 'A'.

[illegible]

1. BREAK ALL SHARP CORNERS (.015/.03).


| | |
|--|---|
|  RED BARN MACHINE | |
| TITLE RBST2300 SERIES SWAGING TOOL; PIN | |
| DWG NO. TOOL# (see chart)-9 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1 |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LINES APPLY AFTER PLATING | |
| SCALE NTS | DATE 6-27-98 |
| SHEET 6 of 9 | |


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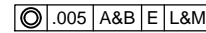
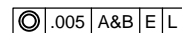
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NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


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|  RED BARN MACHINE | |
| TITLE RBST2300 SERIES SWAGING TOOL; GUIDE | |
| DWG NO. TOOL# (see chart)-7 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | USED ON BEARING SEE Pg. 1 |
| SCALE NTS | DATE 6-27-08 |
| SHEET 5 of 9 | |


| | |
|---|--|
|  RED BARN MACHINE | |
| TITLE RBST2300 SERIES SWAGING TOOL; ROLLER (QTY. 3) | |
| DWG NO. TOOL# (see chart)-5 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1 |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | |
| SCALE NTS | DATE 6-27-98 |
| SHEET 4 of 9 | |

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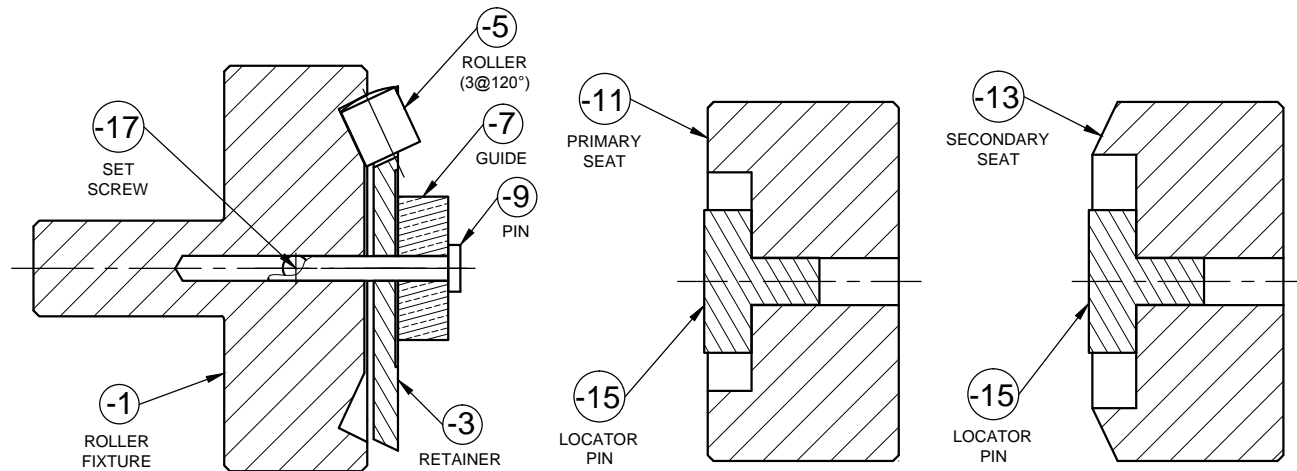
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

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|  RED BARN MACHINE | |
| TITLE RBST2300 SERIES SWAGING TOOL; RETAINER | |
| DWG NO. TOOL# (see chart)-3 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | USED ON BEARING SEE Pg. 1 |
| SCALE NTS | DATE 6-27-98 SHEET 3 of 9 |

| | | | |
|--|--------|--|----------|
|  RED BARN MACHINE | | | |
| TITLE | | RBST2300 SERIES SWAGING TOOL; ROLLER FIXTURE | |
| DWG NO. | | TOOL# (see chart)-1 | REV 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX \pm .005 .XX \pm .01 .X \pm .1 FRACTIONS \pm 1/32 ANGLES \pm 5° | | DRAWN BY: PERRITT APPROVED HEAT TREAT RC 55-60 FINISH SPEC BLACK OXIDE | |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | | USED ON BEARING SEE Pg. 1 | |
| SCALE | N.T.S. | DATE | 6-27-08 |
| | | SHEET | 2 of 9 |

| REVISIONS | | | | |
|-----------|--|----------|---------|----------|
| REV | DESCRIPTION | DATE | INITIAL | APPROVED |
| 1 | CHANGED -5 ROLLER RADUIS FROM .005 - .010, TO .015 - .020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE. | 7/7/08 | WP | DW |
| 2 | ADDED ST2345 INFORMATION, CHANGED -9 FLAT FROM .375-.400, CHANGED -11 & -13 CENTER DEPTH FROM.228, AND REMOVED "K" FROM ALL TOOL No.'s WITH ENGRAVING NOTES TO CHECK FIRST PAGE FOR PREFIX TO TOOL No. | 11/19/08 | WP | DW |
| 2A | CH'D T/N FROM ST. | 11/19/09 | RJC | |
| 3 | -1 CH'D TOL.(H) WAS +/--.002 IS +/--.005. | 6/17/13 | BIM | GE |



NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.


| BEARINGS & TOOLS COVERED | |
|----------------------------|----------|
| BEARING # | TOOL # |
| 412-310-400-107 | RBST2345 |
| 412-310-400-107 | RBST2345 |
| S251W125-5, CAS12-31A1-518 | RBST2369 |
| S251W125-5, CAS12-31A1-518 | RBST2369 |
| | |
| | |
| | |
| | |
| | |
| | |

| ASSY QTY | B/O | PART # | UNIT QTY | DESCRIPTION | B/O INFORMATION OR SPECIFICATIONS | Pg. |
|----------|-----|--------|----------|-----------------------|-----------------------------------|-----|
| | | -1 | 1 | ROLLER FIXTURE | SEE CHART | 2 |
| | | -3 | 1 | RETAINER | SEE CHART | 3 |
| | | -5 | 3 | ROLLER | SEE CHART | 4 |
| | | -7 | 1 | GUIDE | SEE CHART | 5 |
| | | -9 | 1 | PIN | SEE CHART | 6 |
| | | -11 | 1 | PRIMARY SEAT | SEE CHART | 7 |
| | | -13 | 0 or 1 | SECONDARY SEAT | SEE CHART | 8 |
| | | -15 | 1 or 2 | LOCATING PIN | SEE CHART | 9 |
| B/O | | -17 | 1 | SOCKET HEAD SET SCREW | #8-32 x 1/4 | N/S |

| RED BARN MACHINE | |
|---|---|
| TITLE | RBST2300 SERIES TRI-ROLLER SWAGING TOOLS |
| DWG NO. | TOOL # (SEE CHART ABOVE) |
| REV | 3 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES | DRAWN BY: PERRITT |
| TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 | APPROVED |
| FRACTIONS ± 1/32 ANGLES ± 5° | HEAT TREAT LISTED PER ITEM |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | FINISH LISTED PER ITEM |
| SCALE NTS | USED ON BEARING |
| DATE 6-27-08 | SEE ABOVE |
| SHEET 1 of 9 | |

[illegible]

NOT APPROVED FOR PRODUCTION
APPROVED FOR PRODUCTION

| | |
|--|---|
|  RED BARN MACHINE | |
| TITLE -- | |
| DWG NO. -- | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° | DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC |
| UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | USED ON MODEL |
| SCALE NTS | DATE 8-15-07 |
| SHEET 1 of 1 | |

NOT APPROVED FOR PRODUCTION

| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| | | | |

| PART # | QTY | DESCRIPTION |
|--------|-----|-------------|
| -1 | 1 | -- |
| | | |

| | | | |
|--|---|--------------------------------|---------------------------|
| USED ON MODEL ? | DRAWN BY: PERRITT | <div>RB</div> RED BARN MACHINE | |
| | CHECKED | | |
| | HEAT TREAT | | |
| | FINISH SPEC | | |
| | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5° | TITLE | |
| | UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING | DWG NO. | REV. |
| | | SCALE NTS | DATE 1-28-06 SHEET 1 of 1 |